

Date: Tuesday, 6/13/2006 10:04:25 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SPRING		
Job Number	27366			Part Number	: D31131		
Estimate Number	10862			Drawing Number	: D3113 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 6/13/2006	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	NC			Material	:		
First Issue	: 6/5/2006	Type	: PURCHASED PARTS	Due Date	: 6/30/2006 Qty: 4 Um: Each		
Previous Run	:						
Written By	<u>See comment below</u>						
Checked & Approved By	:						
Comment	: Est. A 02.05.16 New Issue NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET	
2.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.0500 sf(s)/Unit Total : 0.2000 sf(s) Spring	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Check dims to dwg Deburr sharp edge 0.005 to 0.010	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: # 408	

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Drawing Name: SPRING

Job Number: 27366

Part Number: D31131

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



U J b0de/4

Date: Monday, 6/5/2006 7:47:13 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPRING		
Job Number	: 27366					
Estimate Number	: 10862					
P.O. Number	:			Part Number	: D31131	
This Issue	: 6/5/2006 S.O. No. :			Drawing Number	: D3113 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / / Type : PURCHASED PARTS			Drawing Revision	: B	
Previous Run	:			Material	:	
Written By	:			Due Date	: 6/30/2006	
Checked & Approved By	: <u>JJ 06 06 05</u>			Qty:	4 Um: Each	
Comment	: Est. A 02.05.16 New Issue NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: _____ Make as per dwg D31131 Possible Supplier: Industrial Laser cutting (replaces Bell p/n 205-030-803-001) Material release note required	<i>M304S16 GA</i> <i>0.063" thick</i> <i>M7106</i> <i>batch - 1422</i> <i>(0.050 sq ft)</i> <i>MM 06 06 07</i>
2.0	D31131F Water Set	Spring	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Spring	<i>Prog rev. B</i> <i>Draw rev. B</i> <i>MM 06 06 07 (4)</i>
3.0	PACKAGING QC 2	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<i>MM 06 06 08 (4)</i>
4.0	QC8	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Check dims to dwg Deburr sharp edge 0.005 to 0.010	<i>Ja-06-12 (4)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>2408</u>	<i>Ro-06-14 (4)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/06/12	4.1	Deburring after QC 8. Make a step with barcode. Permanent change.					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/14

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/5/2006 7:47:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 27366

Part Number: D31131

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21



56106/14

4

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

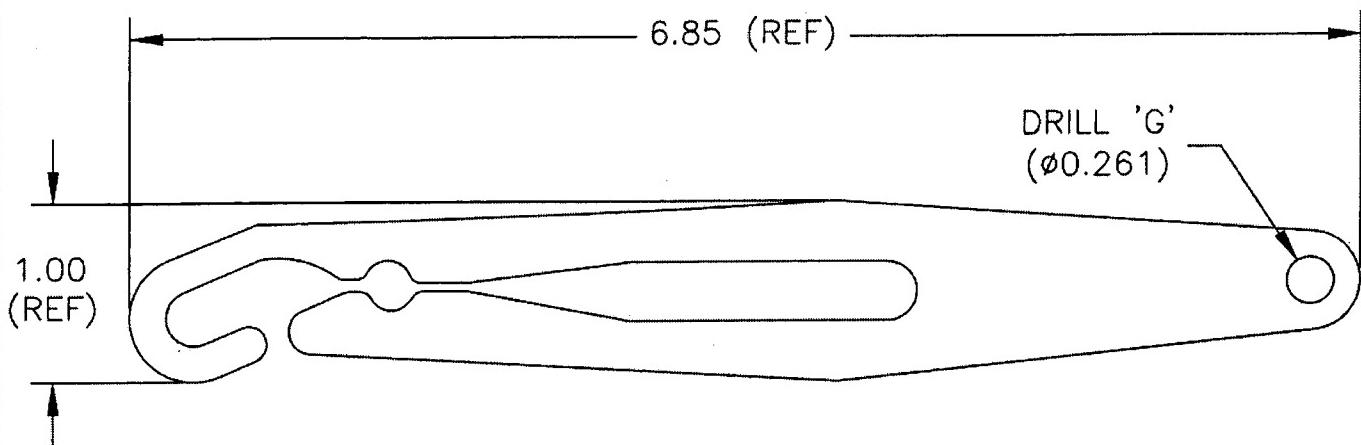
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3113	SHEET 1 OF 1
DATE	TITLE	SCALE	
04.10.18	SPRING	1:1	
A	02.04.12	NEW ISSUE	
B	04.10.18	ADD PART MARKING; ADDED ANNEALED	

RELEASED
04.11.23



D3113-1 SPRING

NOTES:

- 1) MACHINE PER DWG FILE "D3113-B1.DWG"
- 2) MATERIAL: ANNEALED 16 GAUGE (0.063" REF) AISI 304/316 SS SHEET PER MIL-S-5019 (REF DART SPEC M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27366

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DART AEROSPACE LTD	Work Order:	27366
Description:	Part Number:	3113-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>J</u>	Prototype Approval:	<u>J</u>
Date:	08.06.08	Date:	06.06.12	Date:	06.06.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	